

Message Text

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ACTION EB-07

INFO OCT-01 CIAE-00 COME-00 DODE-00 NSAE-00 TRSE-00 EUR-12

ERDA-05 ISO-00 MC-02 EA-06 NEA-09 /042 W

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P 041105Z APR 75

FM USMISSION OECD PARIS

TO SECSTATE WASH DC PRIORITY 6348

C O N F I D E N T I A L SECTION 01 OF 02 OECD PARIS 08400

EXCON

E.O. 11652 XGDS1

TAGS: ESTC, COCOM, BU, GW

SUBJECT: GERMAN N/C MACHINING CENTERS TO BULGARIA-
IL 1091 AND 1572

REF: COCOM DOC. (75) 645

1. URGENCY PROCEDURE: TWO MACHINING CENTERS, TYPE TC-1-800 SK 70, EACH EQUIPPED WITH NUMERICAL CONTROL, TYPE UMAC 7-32 C PLUS ESP DISK STORE INCLUDING ACCESSORIES, SPARE PARTS AND TOOLS FOR THE ABOVE. TOTAL VALUE \$960,000.
 2. END-USER MACHINE TOOL PLANT ZMM (PLANT FOR METAL CUTTING MACHINES), ILLIENSKI CHAUSSEE 8, SOFIA
 3. END-USE: MACHINING OF GEAR BOXES OF TURNING MACHINES. MACHINING CAPACITY OF TRANSFER CENTERS PROPOSED FOR EXPORT IS APPROPRIATE FOR ZMM'S PRESENT ANNUAL PRODUCTION OF APPROXIMATELY 3,000 TURNING MACHINES. IN ADDITION TO NUMERICALLY CONTROLLED MACHINING CENTERS, PROPOSED TRANSACTION INVOLVES UNEMBARGOED WORKPIECE CLAMPING DEVICES, MACHINING TOOLS AS WELL AS PROCESSORS AND POSTPROCESSORS FOR AN UNEMBARGOED HP 9830A COMPUTER PREVIOUSLY EXPORTED TO BULGARIA.
 4. THE NUMERICAL CONTROLS, TYPE UMAC 7-32 C PLUS ESP,
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ARE TO BE EXPORTED TOGETHER WITH ACCESSORIES, SUCH AS

CUTTER-RADIUS COMPENSATION, MAGNETIC DISK STORE ESP (EDITABLE STORED PROGRAM) WITH A CAPACITY OF 3,500 BLOCKS ETC. THEY HAVE A MINIMUM PROGRAMMABLE INCREMENT OF 0.001 MM. HOWEVER, ONLY AN ACCURACY OF 0.00254 MM CAN BE ACHIEVED SINCE THE CONTROLS ARE EQUIPPED WITH INDUCTOSYN SCALES (INCH SYSTEM) OF THE ACCURACY CLASS C. THE CONTROLS ARE COVERED BY ITEM 1572(A) AS THEY USE MAGNETIC TECHNIQUES.

5. THE MACHINING CENTER, TYPE TC 1-800, IS A 3-AXIS NUMERICALLY PAPER TAPE CONTROLLED TRANSFER CENTER WITH A FOURTH AXIS WHICH IS ONLY SELECTED NUMERICALLY. THE CENTER IS SUITABLE FOR THE MANUFACTURE OF WORKPIECES IN SMALL AND MEDIUM SERIES, BUT ALSO FOR LARGE SCALE SERIES PRODUCTION WHEN LINKED TO A PRODUCTION LINE. THE MOVEMENTS ARE CARRIED OUT AS FOLLOWS; IN THE X-AXIS BY THE MACHINE COLUMN, IN THE Y-AXIS BY THE SPINDLE SLIDE AND IN THE Z-AXIS BY THE MACHINE COLUMN WITH SOCLE ON THE BASE PLATE.

POSITIONING ACCURACIES (SLIGHTLY DIFFERING FROM PARAMETERS INDICATED IN PRINTED BROCHURE AND IN THE TENDER) ARE SPECIFIED BY THE MANUFACTURER AS FOLLOWS:

X-AXIS: PLUS-MINUS 0.012 MM PER 300 MM

Y-AXIS: PLUS-MINUS 0.013 MM PER 300 MM

Z-AXIS: PLUS-MINUS 0.009 MM PER 300 MM

(FOR EACH ADDITIONAL 300 MM:

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INFO OCT-01 CIAE-00 COME-00 DODE-00 NSAE-00 TRSE-00 EUR-12

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C O N F I D E N T I A L SECTION 02 OF 02 OECD PARIS 08400

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X-AXIS: PLUS-MINUS 0.01 MM
Y-AXIS AND Z-AXIS: 0.012 MM)

ATTENTION DRAWN TO FACT THAT WITH EXCEPTION OF ABOVE PARAMETERS THE CHARACTERISTICS OF MACHINING CENTER GIVEN IN THE TENDER AND NOT RPT NOT THOSE IN PRINTED BROCHURE ARE CORRECT INDICATION FOR PROPOSED EXPORT. MACHINING CENTER, TYPE TC 1-800 SK 70, IS COVERED BY ITEM 1091(B) ON ACCOUNT OF THE POSITIONING ACCURACY OF THE Z-AXIS.

6. BROCHURES, SPECIFICATION SHEETS, DIAGRAMS, TENDER, ETC. POUCHED APRIL 4. WE HAVE CULLED FROM THE TENDER THE FOLLOWING ADDITIONAL MEASUREMENTS WHICH SEEM PERTINENT:

WORKING CAPACITY FOR AXES: 800 MM
PROGRAMMING FEED IN ALL AXES LINEAR AND CIRCULAR:
1000 TO 2000 MM/MIN
RAPID TRAVERSE SIMULTANEOUSLY IN ALL THREE AXES:
10,000 MM/MIN.
MAIN-SPINDLE DRIVING POWER: 18 KW.

7. URGENCY JUSTIFICATION: IN THE ERRONEOUS BELIEVE THAT EQUIPMENTS INVOLVED WERE EMBARGOED, APPLICANT HAS ALREADY CONCLUDED EXPORT CONTRACT FIXING DEADLINES FOR SHIPMENT. APPLICANT FACES PENALTIES FOR NONFULFILLMENT OF CONTRACT IF THESE DEADLINES ARE NOT OBSERVED.
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8. ACTION REQUESTED: INSTRUCTIONS BY APRIL 8.
TURNER

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Message Attributes

Automatic Decaptioning: X
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Draft Date: 04 APR 1975
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Decaption Note:
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Disposition Approved on Date:
Disposition Authority: GolinoFR
Disposition Case Number: n/a
Disposition Comment: 25 YEAR REVIEW
Disposition Date: 28 MAY 2004
Disposition Event:
Disposition History: n/a
Disposition Reason:
Disposition Remarks:
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Margaret P. Grafeld
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05 JUL 2006

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